

Date: Monday, 3/19/2007 4:38:57 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIGHT ARM WELDMENT
Job Number : 31303	
Estimate Number : 11876	
P.O. Number : N/A	Part Number : D33547
This Issue : 3/19/2007 S.O. No. : N/A	Drawing Number : D3354 REV A/B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A/B
Previous Run : 29904	Material : N/A
	Due Date : 3/26/2007
Written By : <u>[Signature]</u>	Qty: 6 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : est rev. 06.01.14 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	M1010B1000X02000	1010-1025 Steel Bar
-----	------------------	---------------------



Comment: Qty.: 0.5597 f(s)/Unit Total: 3.3579 f(s)
1010-1025 BAR

AISI 1010-1025 Steel bar 2.00" x 1.00"

Batch: M19296 + 1 piece

07/03/23 6

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 6.100" long

07/03/23 6

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA611 and Dwg D3353

2- Deburr

07/03/23 6

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/03/23 6

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/03/23 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:38:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 31303

Part Number: D33547

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

67/3/26

(E)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(G)

Comment: FINAL INSPECTION/W/O RELEASE

67/03/28

Job Completion



12 8-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

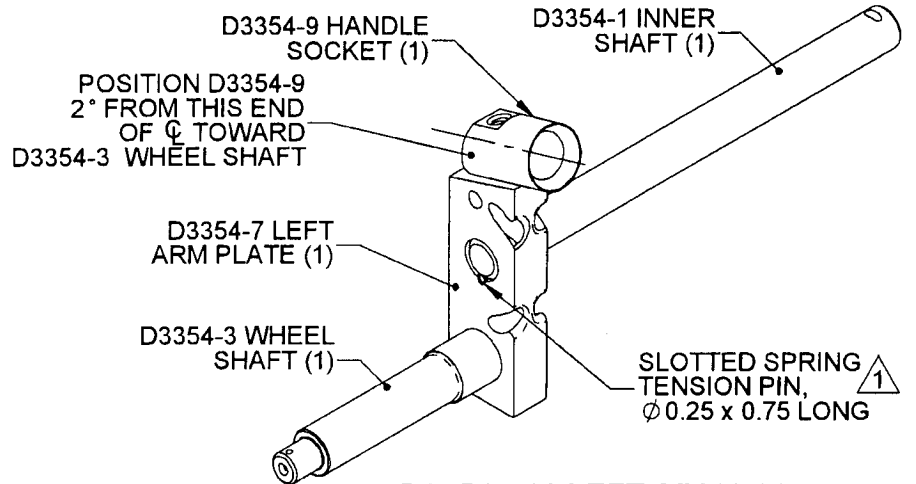
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

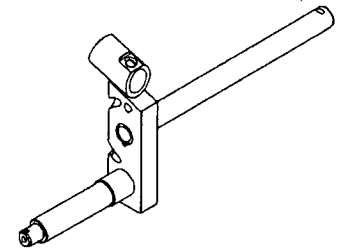


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CHECKED <i>h</i>	APPROVED <i>h</i>	DRAWING NO. LEFT ARM WELDMENT	REV. B SHEET 1 OF 7
DATE 07.02.02	TITLE D3354 SCALE 1:4		
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	

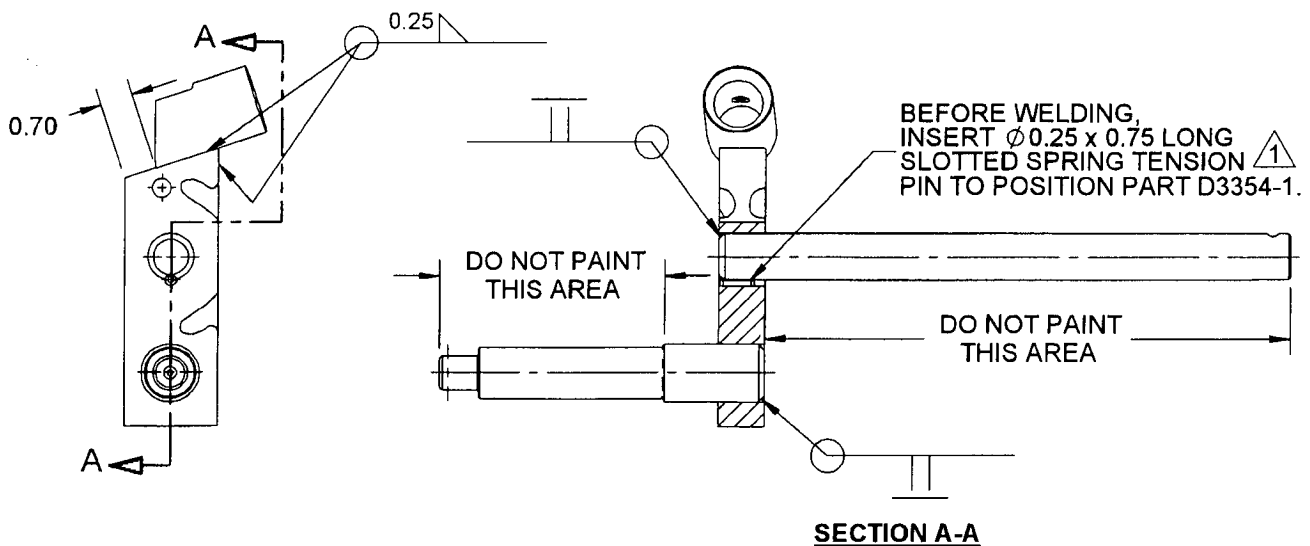
RELEASED
07.02.02



D3354-041 LEFT ARM WELDMENT



D3354-042 MIRROR ARM WELDMENT



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 0054.13
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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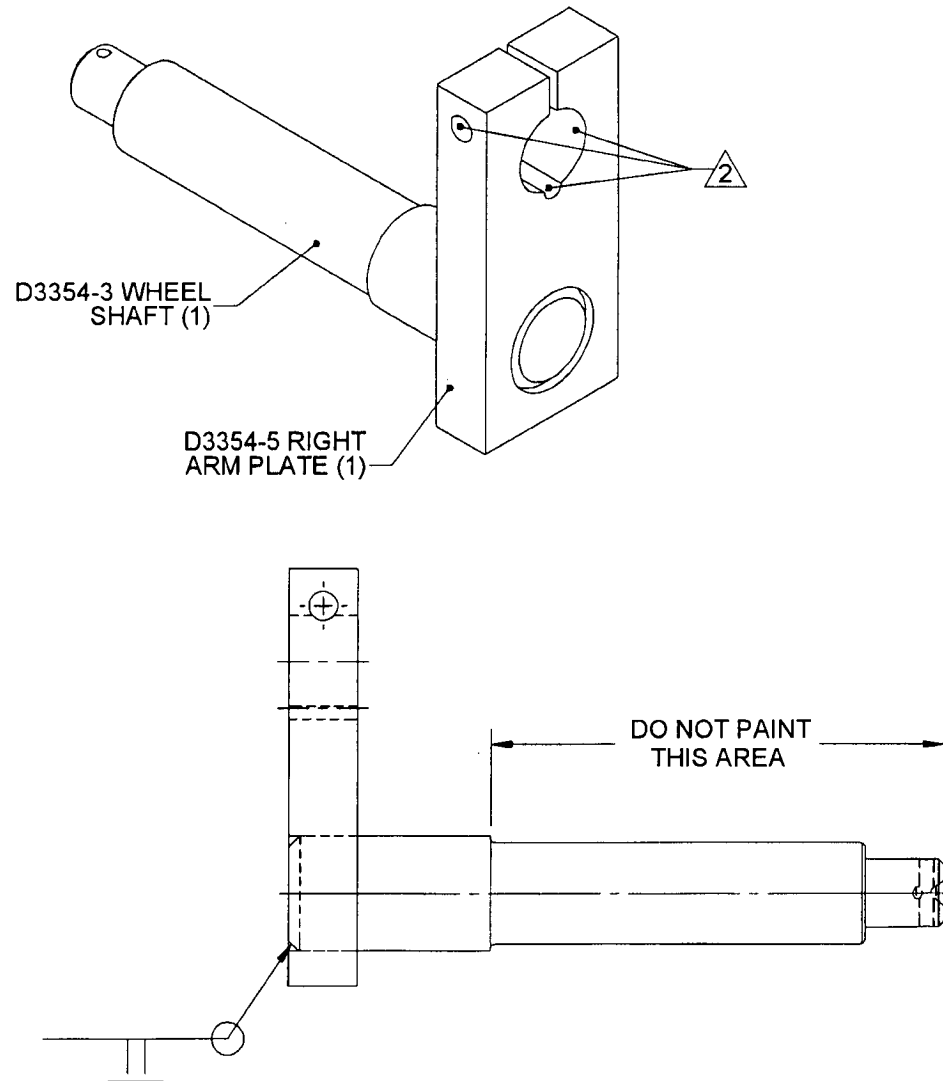
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
07.02.02



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3 WITHOUT NOTICE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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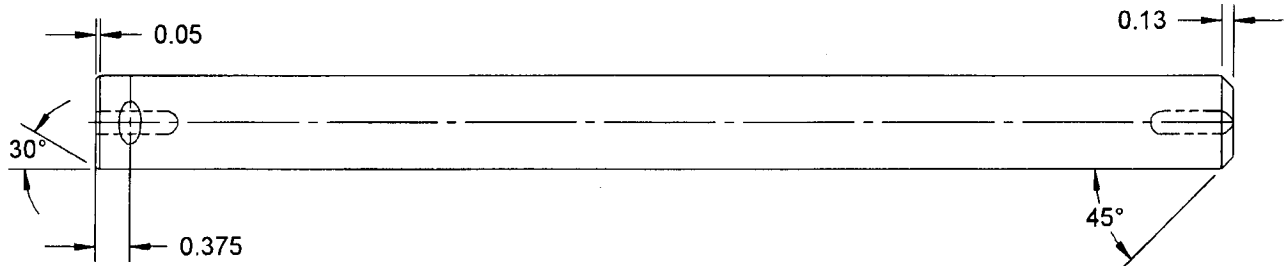
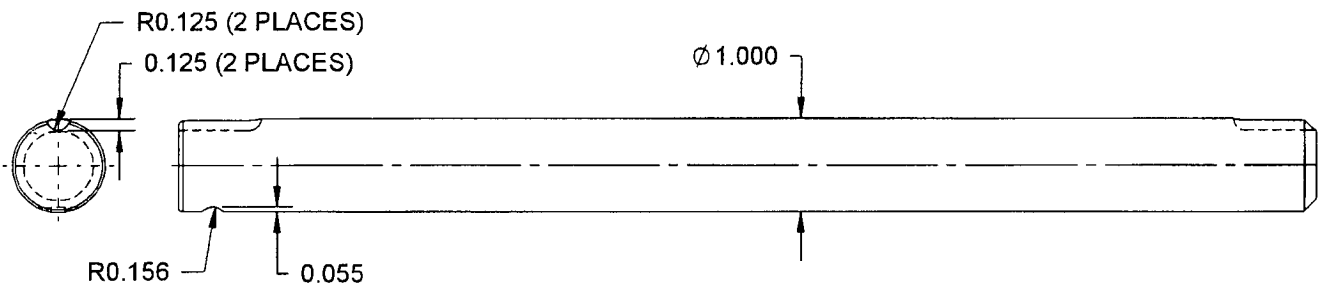
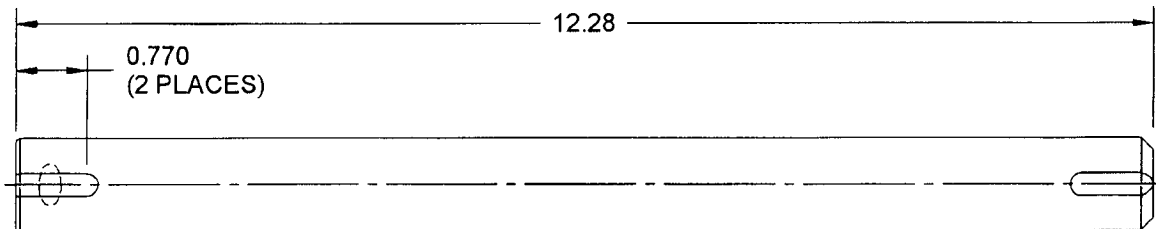
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
[Signature] 07.02.02



D3354-1 INNER SHAFT

NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-01 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

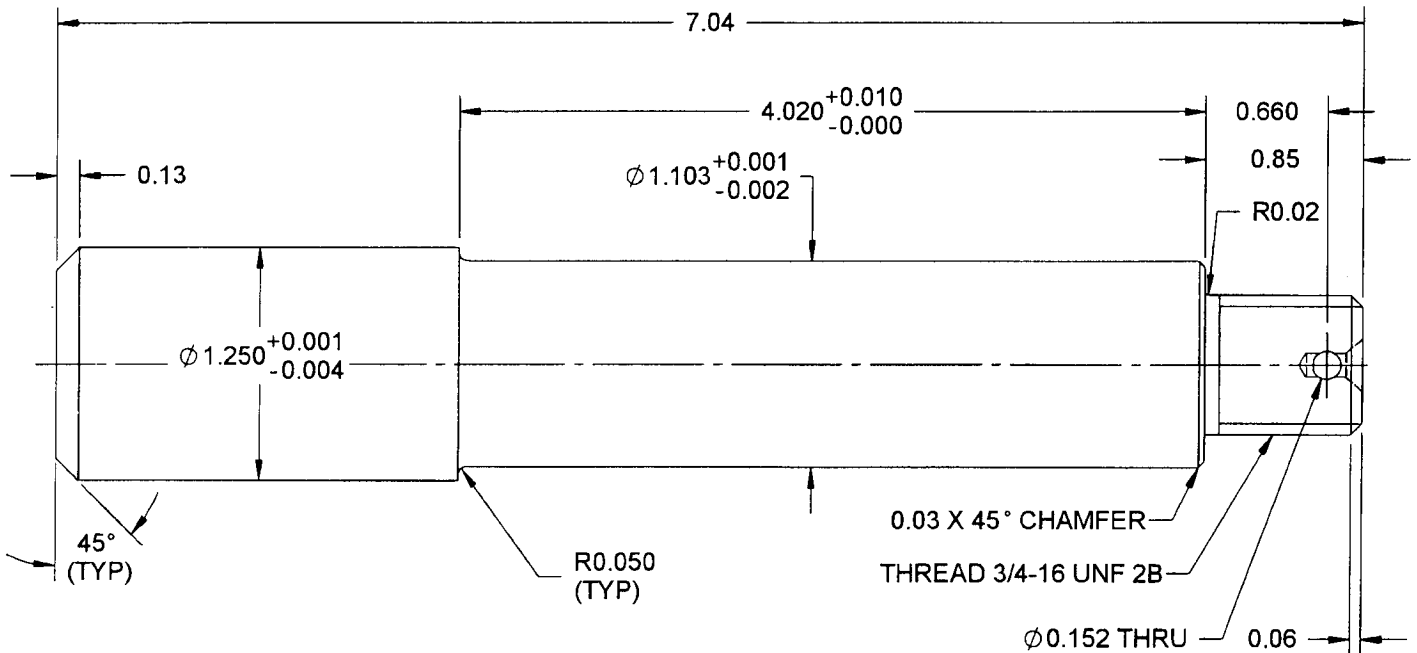
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
h 07.02.02**D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, ϕ 1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

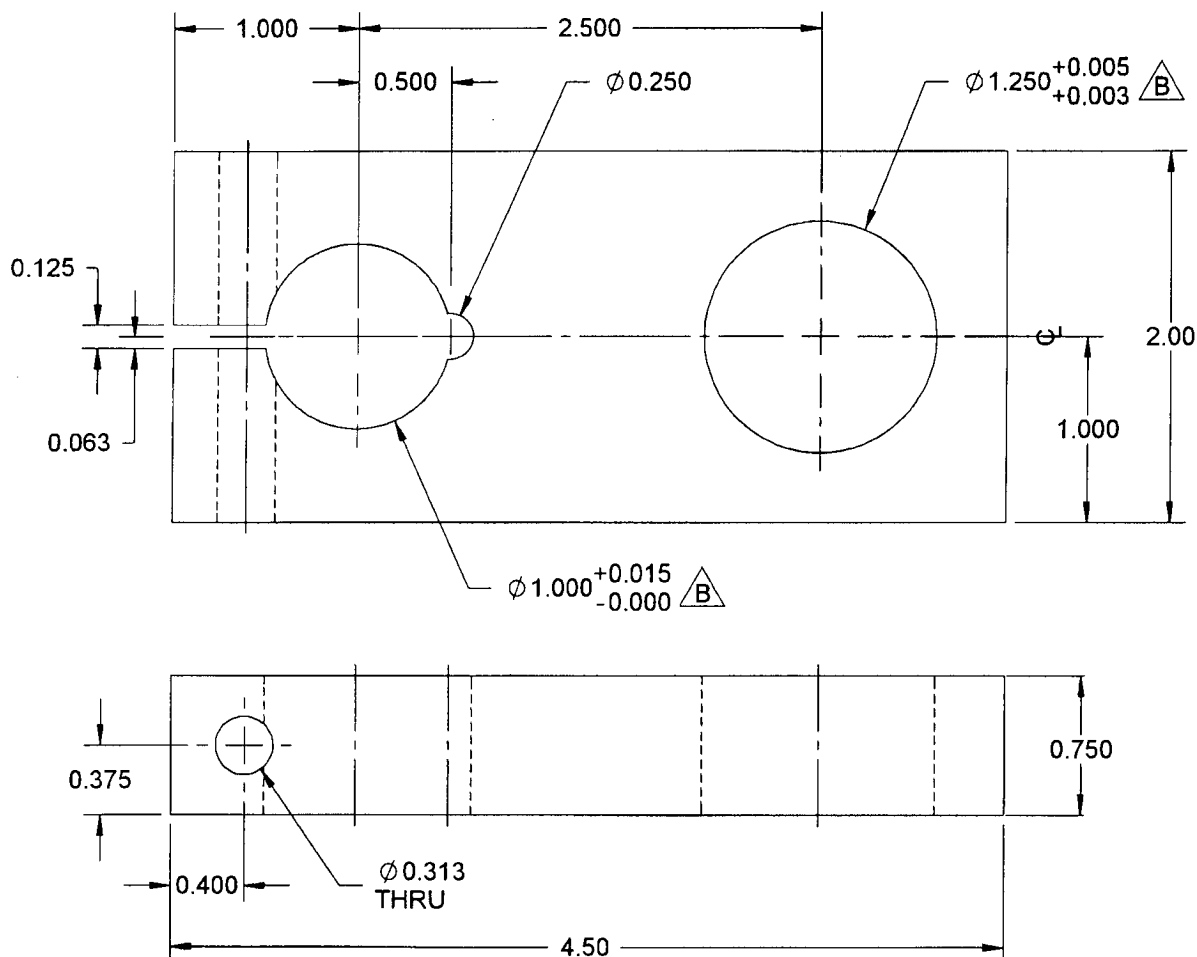
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
07.02.02**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

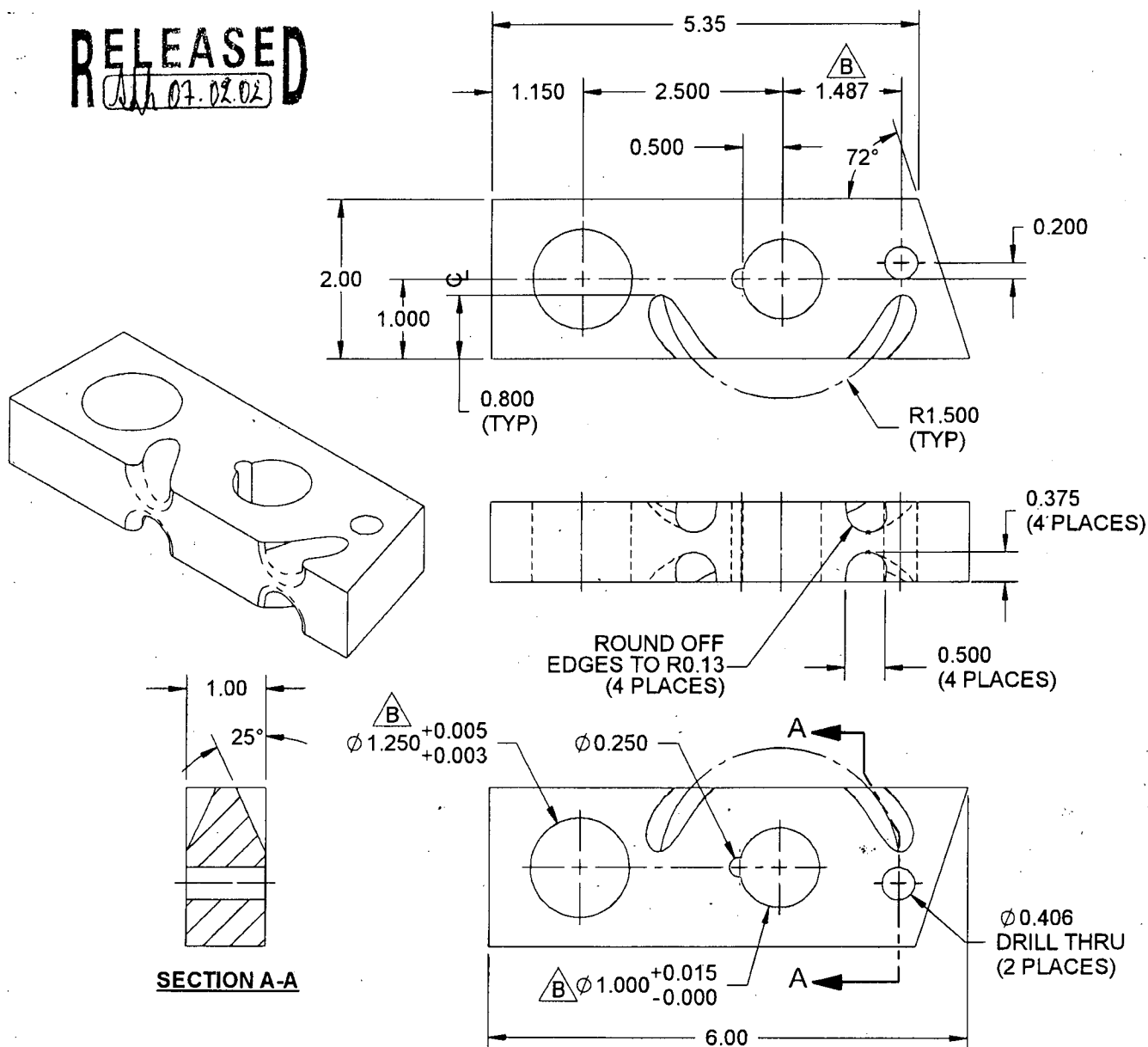
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DATE 07.02.02		TITLE LEFT ARM WELDMENT SCALE 1:2	

RELEASED
JUL 07 09 02



D3354-7 LEFT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD
STEEL BAR (REF. DART SPEC. M1010-B)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

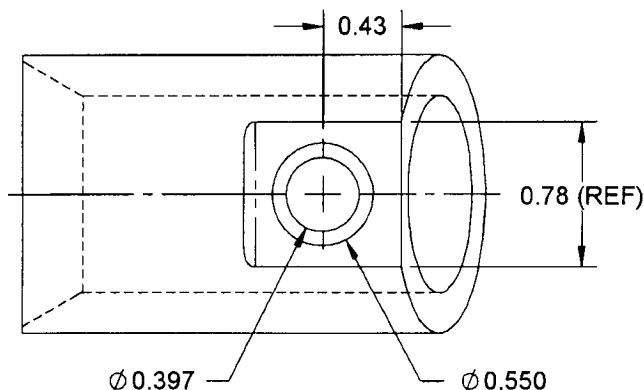
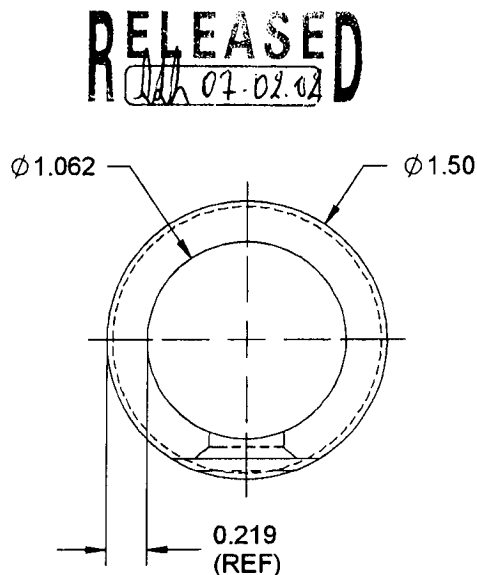
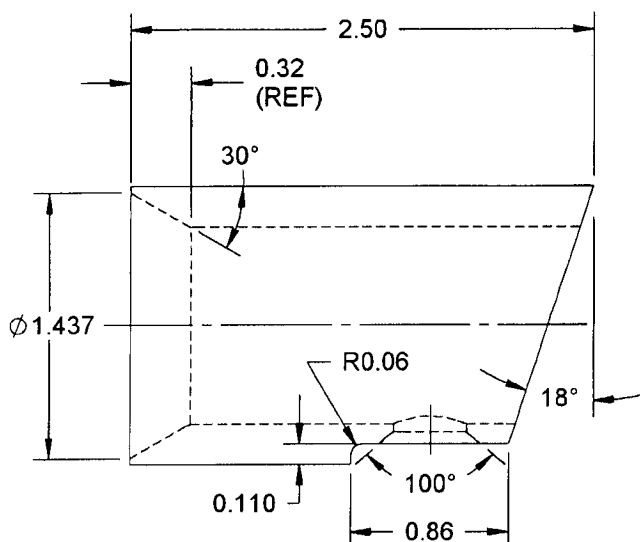
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1



D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DART AEROSPACE LTD		Work Order:	31303
Description: Left Arm Plate		Part Number:	D3354-7
Inspection Dwg: D3354 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.35	± 0.30	5.348	—			
1.150	± 0.10	1.149	—			
2.500	± 0.05	2.501	—			
1.487	± 0.05	1.485	—			
0.200	± 0.05	0.199	—			
0.800	± 0.10	0.797	—			
1.006	± 0.10	0.999	—			
2.00	± 0.30	1.999	—			
0.375	± 0.10	0.380	—			
0.500	± 0.10	0.500	—			
Ø 1.250	+0.005 -0.003	Ø 1.254	—			
Ø 0.250	+0.005 -0.001	Ø 0.251	—			
Ø 1.000	+0.015 -0.006	Ø 1.003	—			
Ø 0.406	+0.006 -0.001	Ø 0.408	—			
6.00	± 0.30	5.994	—			
1.00	± 0.30	0.997	—			

Measured by: <i>ML</i>	Audited by: <i>J.L</i>	Prototype Approval:
Date: 07/03/23	Date: 07/03/23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

